

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000317**Date Inspected:** 12-Jul-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe:**Fracture Critical****Index Lot #:** B71-041-07a**Witness Lot #:** B71-041-07**Bridge No:** 34-0006**Component:** Bid 52**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** Figure 2.3 fillet welds

N/A

WPS ID #: PWPS-B-T-3113

N/A

Base Metal: A709-HPS 485W T2/Z

N/A

PQR ID #: HP2007151

N/A

Thickness: 90 mm

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS 5.1/E7018-1

N/A

Positions: 3-F (single and multiple passes)

N/A

Backing Material: N/A

N/A

CWI: Xu Bing

N/A

Average Amps: 168

N/A

AWS Code: AWS 1.5 2002

N/A

Average Volts: 22.3

N/A

Applicable Sec: AWS 5.10.3

N/A

Travel Speed: 78.9 mm/min

N/A

Heat Input: 2.85 KJ/mm

N/A

Preheat: 164 Celsius

N/A

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector witnessed welding of the Procedure Qualification (PQR) test plate using single and multiple passes (2) with shielded metal arc welding (SMAW), THJ506Fe-1, 4.0 mm diameter electrode in the vertical(3F) position The welding was performed per the AWS D1.5-02, Fillet Weld WPS Qualification Section 5.10 requirements. The welding appeared to comply with contract documents.

The QA inspector did not observe any significant air movement by the testing area during welding.

Summary of Conversations:

The QA inspector did not have any significant conversations on this date

Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING WITNESS REPORT

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Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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